Date: User: Tuesday, 12/08/2008 11:26:15 AM

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 41164

Estimate Number

: 10272

P.O. Number

This Issue

: 12/08/2008

: NC

: // : 39545

Type

S.O. No. :

: SMALL /MED FAB

Part Number Drawing Number

Due Date

Drawing Name

: D2562001 : D2562 REV D

: STRUT

Project Number

: N/A

Drawing Revision

: D

Material

: 22/08/2008

Qty:

10 Um:

Each

Written By

Prsht Rev.

First Issue

Checked & Approved By

Comment

Previous Run

: Est F 02.04.15

Added dwg Rev.B1 NG

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M304TR0500W035

304 RD Tube .500 x .035W



Comment: Qty.:

1.7920 f(s)/Unit Total: 17.9204 f(s)

304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall

N 123 329

NC BRAKE



2.0

Punch to length as per Dwg D2562

3.0 SMALL FAB 1

Comment: NC BRAKE

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL/MED FAB RESOURCE

1- Bend end as per Dwg D2562 Angle "D"

2-Deburr

4.0

QC5



Comment: INSPECT WORK TO CURRENT STEP

5.0

POWDER COATING

POWDER COATING



M108523



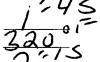
Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:



Dart Ae	rospace L	_td						
W/O:			WORK ORDER	CHANGES		,		
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					 			
							:	
Part No	1	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	
				QA:	N/C Close	d:	_ Date: _	
NCR:		:	WORK ORDER NON-CON	IFORMANCE (NC	R)			

e Action Section B on Description Chief Eng Sign & Date Verification Section C Approval Chief Eng QC Inspector
on Description Sign & Section C Chief Eng QC Inspector

NOTE: Date & initial all entries

Date: T	uesday, 12/08/2008 11:26:15 AM	
User: Li	nda Lacelle	Process Sheet
	er: CU-DAR001 Dart Helicopters Services	Drawing Name: STRUT
Job Numbe	er: 41164	Part Number: D2562001
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	ment: INSPECT POWDER COAT	08-08-77
7.0	PACKAGING 1	PACKAGING RESOURCE #1
Com	ment: PACKAGING RESOURCE #1 Identify and Stock	, ,
	Location:STQ64	AR 08/08/28 X1
8.0	QC21	FINAL INSPECTION/W/O RELEASE
Com	ment: FINAL INSPECTION/W/O RELEASE	Doelsel 39
Job Completion		W 8.08.28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Dart No		DAD # Equit Category NC	·	No DO		Deter	I

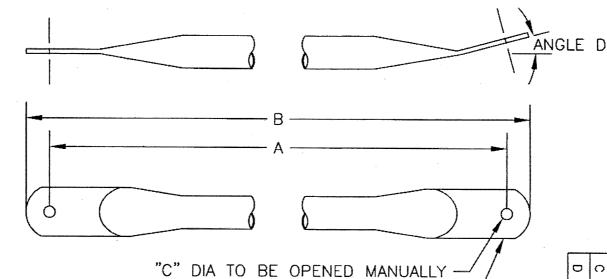
Part No:	PAR #:	Fault Category:	NCR: Yes	No DQA:	Date:
	· .		QA: N/	C Closed:	Date:
!				•	

NCR:			WORK ORE	DER NON-CONFORMANO	CE (NCR)			
		Description of NC	Corrective Action Section B		Verification	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
					<u>.</u>			
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NOTE: Date & initial all entries

Q





PUNCH ENDS PER SPEC CONTROL DRAWING D2727

	PART #	DIM A	DIM B	DIA C	ANG D
	D2562-001	19.68	20.48		10
	D2562-003	20.37	21.17		18
	D2562-005	29.00	29.80		30
	D2562-007	19.22	20.02		0
SI UZ	D2562-011	25.79	26.59	_	16
SHOP COPY RETURN TO RETURN TO ENGINEERING UNCONTROLLED SUBJECT TO AMENI WITHOUT NOTI WORK, ORDI	D2562-013	26.63	27.43		24
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GENERAL NOTES TO SEAMLESS TUBE IS USED

1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)
ENSURE SEAMLESS TUBE IS USED

2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

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PURPOSE

OR COPIED

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CP ESIEN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
HECKED	APPROVED 111	DRAWING NO. REV. D
	养	D2562 SHEET 1 OF 1
ATE		TITLE SCALE
5.05.18	18	STRUT 1:2
Α	96.05.01	NEW ISSUE
σ	98.10.15	UPDATED MATERIAL NOTE (TSR A603)
C	02.06.05	ADD -005; ADD FINISH
0	05.05.18	ADD -007/-011/-013; UPDATE -005

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